

Date: Wednesday, 1/11/2006 4:25:10 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG EXTRUSION
 Job Number : 25452
 Estimate Number : 10326
 P.O. Number : N/A Part Number : D27317
 This Issue : 1/11/2006 S.O. No. : N/A Drawing Number : D2731 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 23331 Material : N/A
 Due Date : 1/30/2006 Qty: 50 Um: Each
 Written By : SPE COMMENT BELOW
 Checked & Approved By : SPE ABOVE USER & DATE
 Comment : Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 3.5858 f(s)

Lug Extrusion D2423

Batch: B23779

M8 06/01/23

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 extrusion to .82"

Batch B23779

M8 06/01/23

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

PG



Issue P.O



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2731-7.

2-Check for crack while loading into the machine.

3-Tumble

4-Deburr any rough edges after tumbling

Matco P.O. # 00000416 AP
06/01/26

3.6

RG

Receive & inspect for transport damage

CY 06/02/28

50

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC2 SECOND CHECK



Comment: SECOND CHECK

06-07-02 50

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☒ DQA: ☒ Date: 06/03/21

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:25:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG EXTRUSION

Job Number: 25452

Part Number: D27317

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06:03:05

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-06

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M 06 03 14 (50)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DL 06/03/14 (50)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 148

A 06/03/17 (50)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/21 (50)

Job Completion



W 06.03.21

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

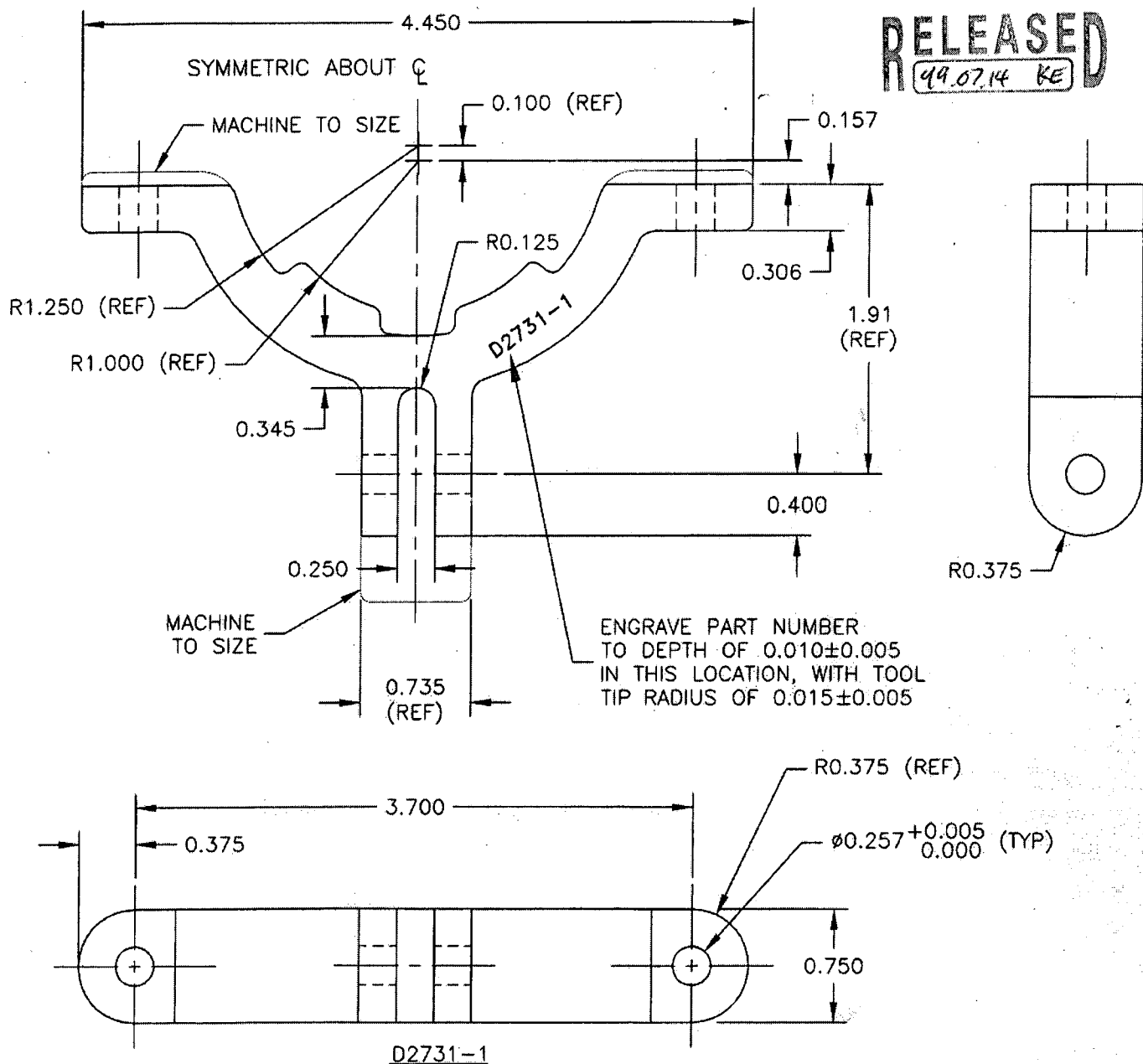
QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	



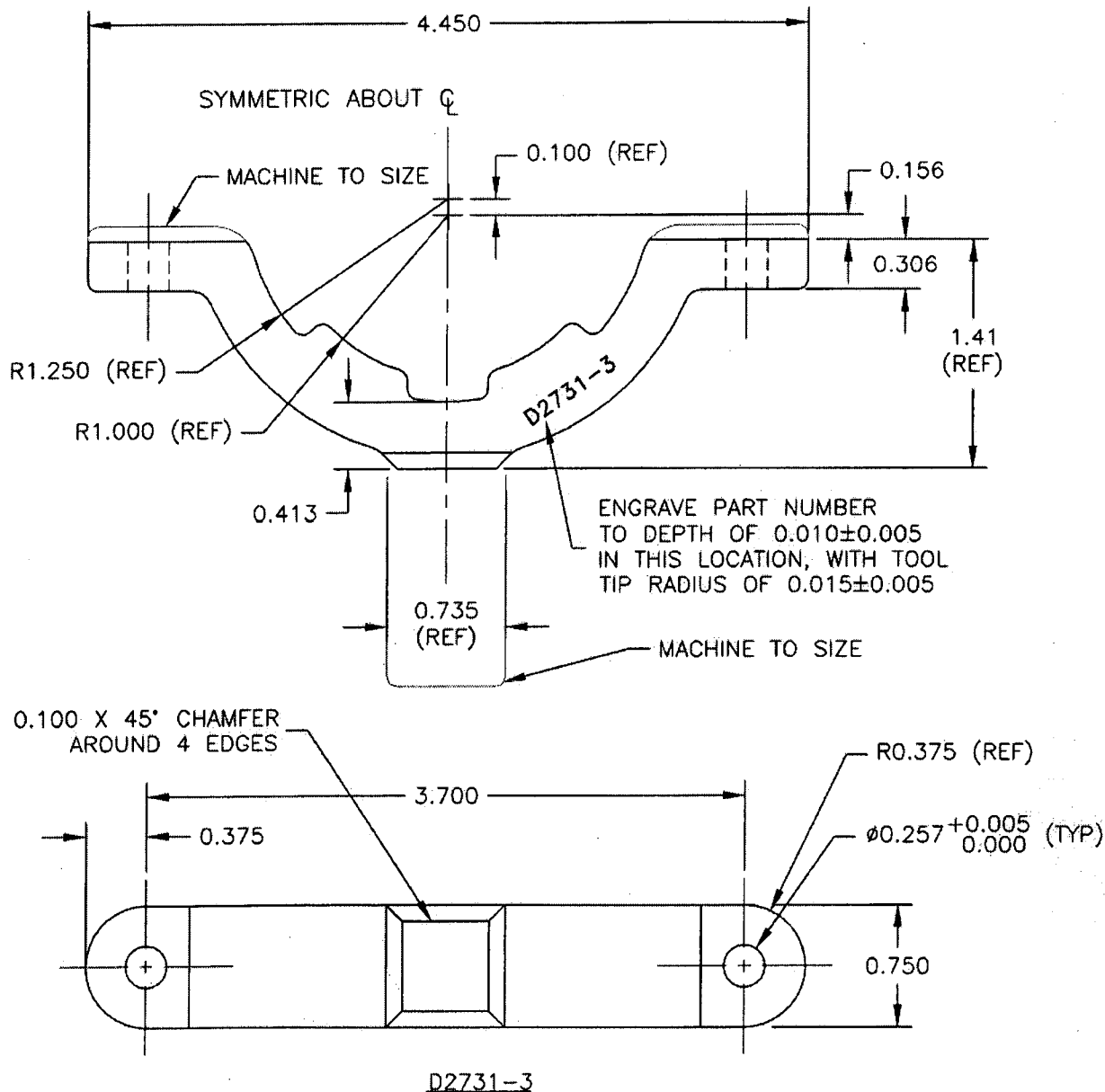
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

IT IS THE POLICY OF DART AEROSPACE USA, INC. TO AMENDMENTS WITHOUT NOTICE



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DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *KE*



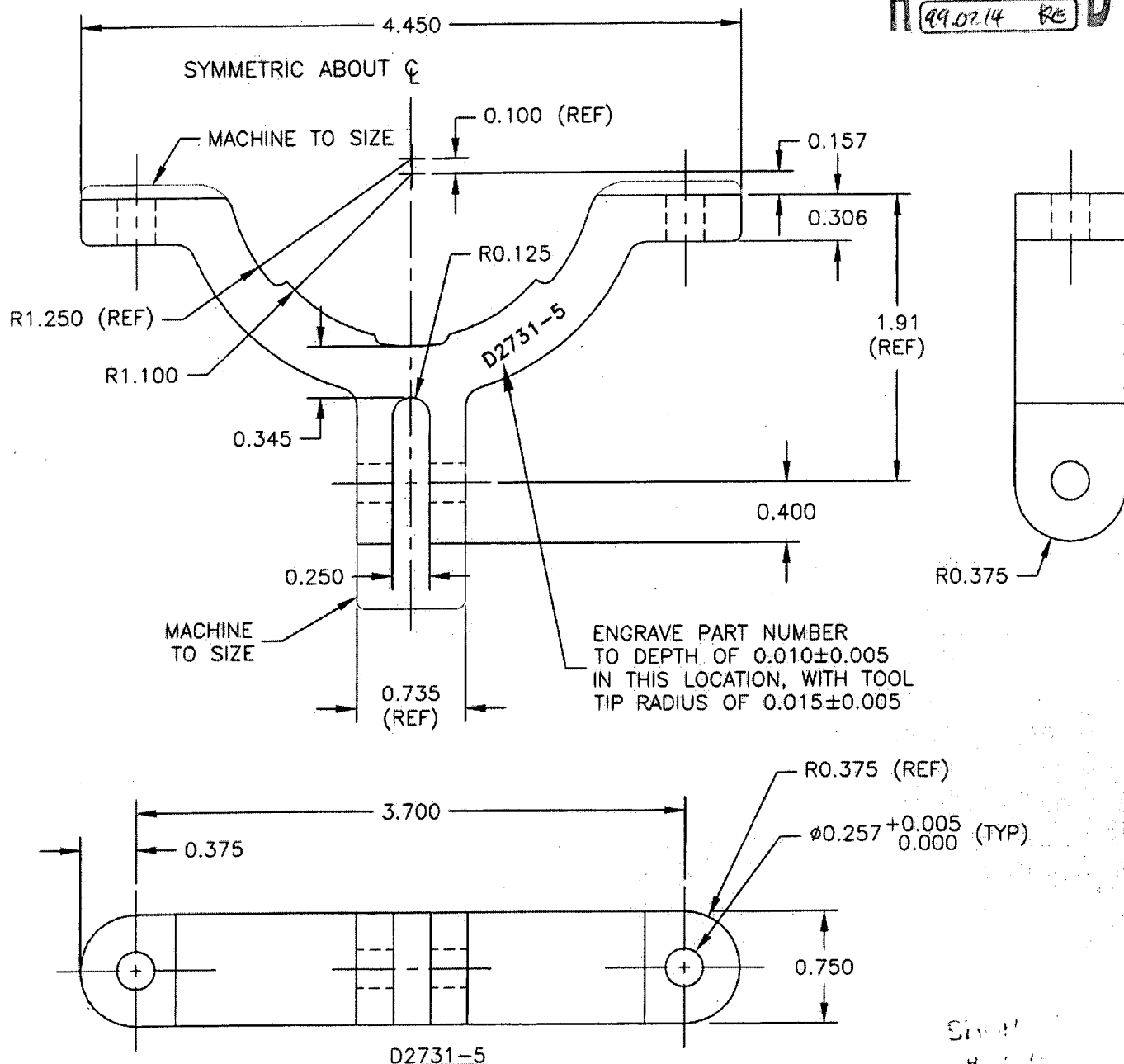
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POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
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CHECKED KE	APPROVED [Signature]	DRAWING NO. D2731	REV. B SHEET 3 OF 4
DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1

RELEASED
99.07.14 KE



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
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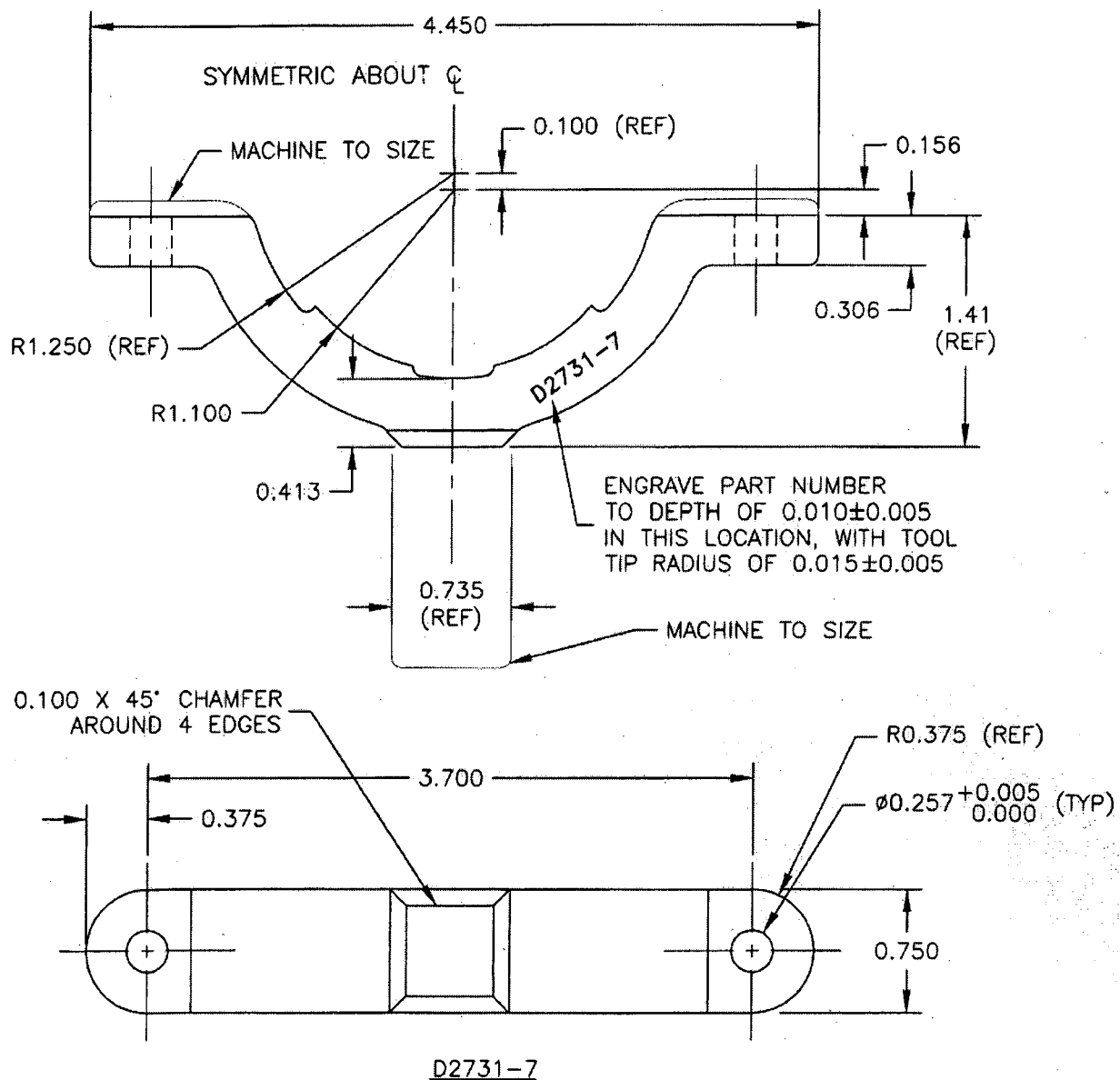
UNCONTROL

SUBJECT TO APPROVAL
WITHOUT NOTICE

WORK ORDER

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *KE*

MAKE FROM EXTRUSION D2423
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WITHOUT NOTICE

Copyright 1998 by DART AEROSPACE USA, INC

WORK ORDER
NO. 25452



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

50

PART NUMBER

D2731-7

PART NAME

Mounting Lug

P.O. NUMBER

446

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shigi (Regula) Walz".

Shigi (Regula) Walz

Vankleek Hill, February 28, 2006

A large, stylized handwritten signature in black ink, possibly reading "R. 03.02".